








Work Order ID 71745

Monday, July 11, 2011 9:08:34 AM



Page 1

Item ID: D3836-042 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly (Basket Lid, RH) Stop 
Start Date: 7/11/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/15/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: H Date: 11-07-11 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3836	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: ~~M115778~~ M115778

6- grind weld flush where indicated on dwg

SAD 11-07-20

11.07.21 (2)



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	0	BE 11/07/25 11.07.25	
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				nl	11	07 21 (2)	
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WAS</u> Memo	0.00 0.00				WAS	11.07.25	(2)	



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/7/25 

11/7/25
②

Picklist Print

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Page 1

Work Order ID: 71745

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)



Start Date: 7/11/2011

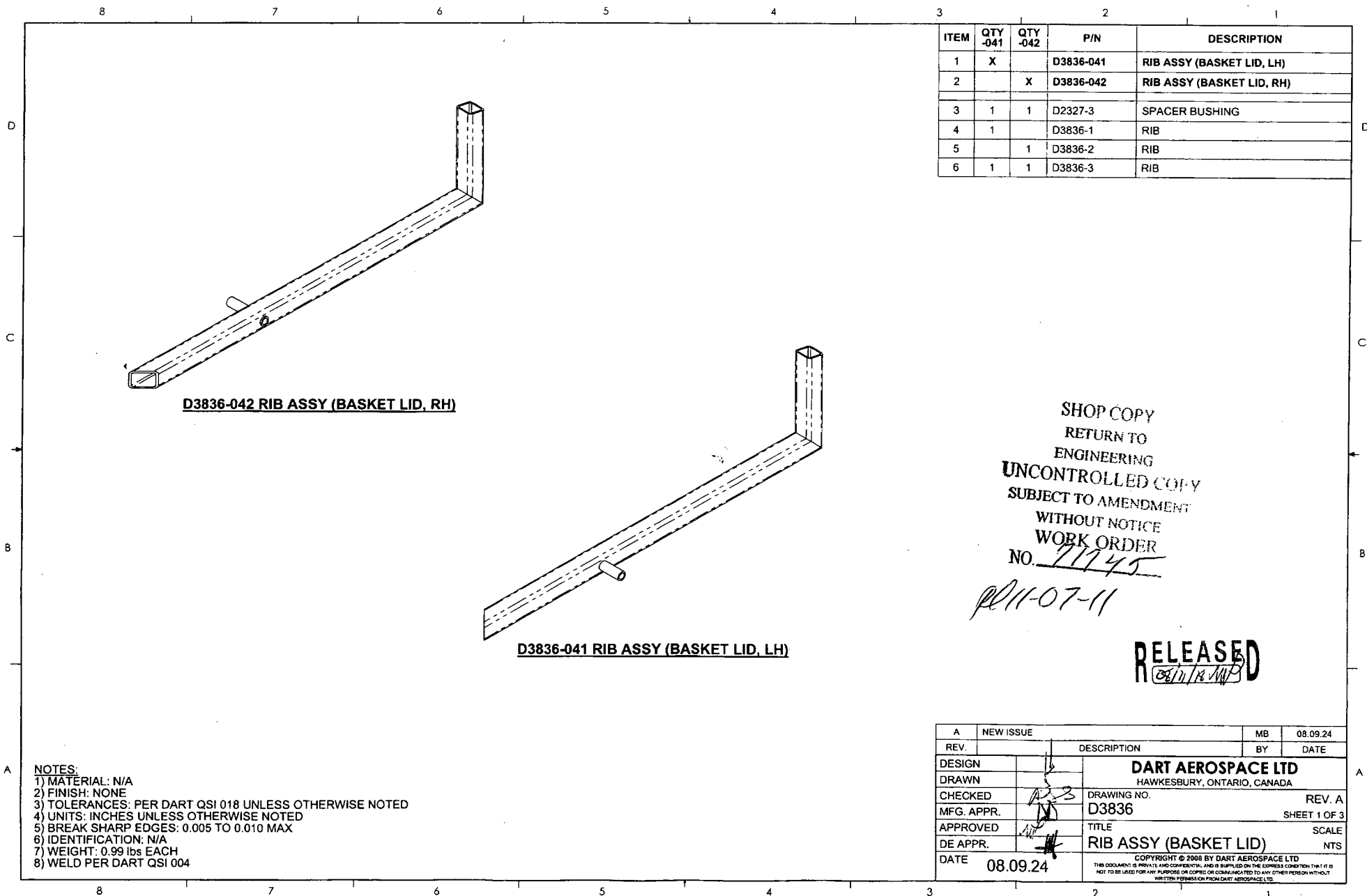
Required Date: 7/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3  Spacer Bushing		Manufactured	No			100	Each	14.0000	1	2		11.07.21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
				70884				14					
M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	697.9792	1.7808	3.749053		11-07-20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT018				91.83716					
				117598				14.13846					
				117636				77.6987					
				WA				500					
				118181				500					
				WA007				106.1419906					
				116267				99.549272					
				116763				6.5927186					
										3.7491			



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71745

PH-07-11

RELEASED
08/11/08 MB

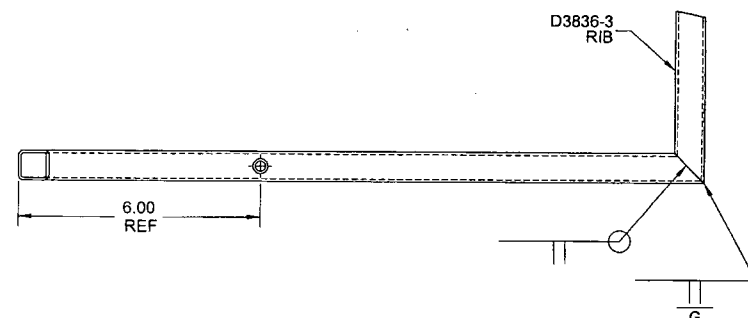
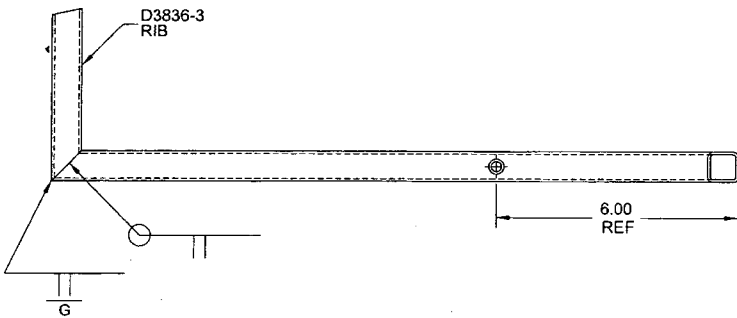
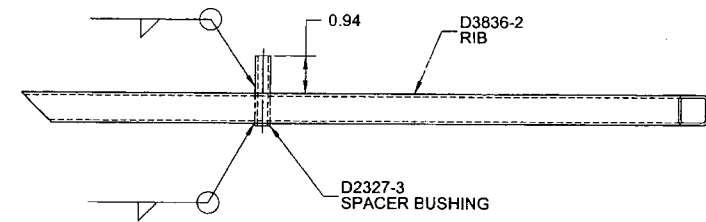
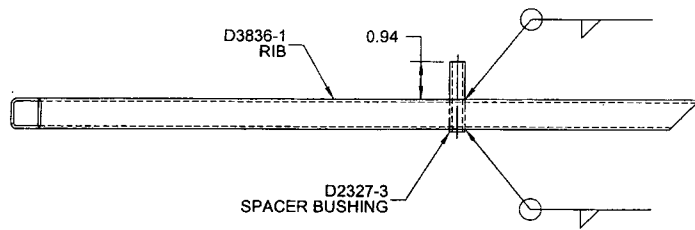
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A SHEET 1 OF 3
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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71745



D3836-041 RIB ASSY (BASKET LID, LH)

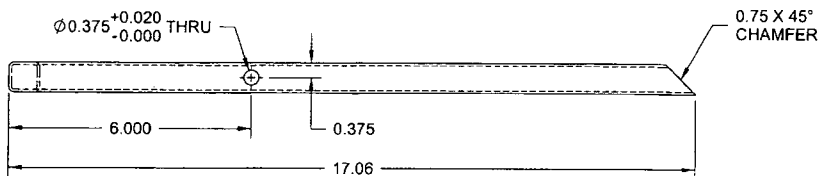
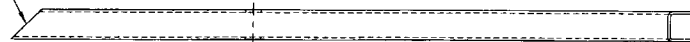
D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
28/11/18 MRP

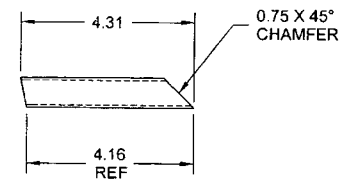
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

0.75 X 45°
CHAMFER

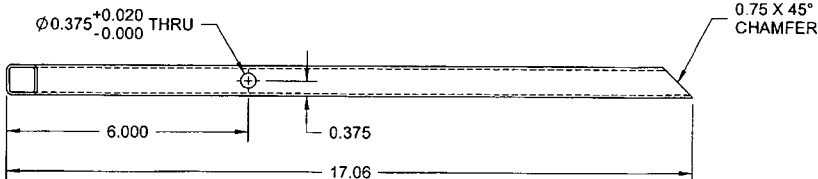
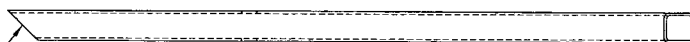


D3836-1 RIB

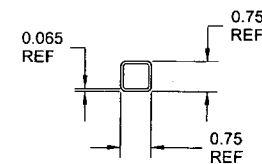


D3836-3 RIB

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3836	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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